



Dart Aerospace Ltd.
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D4776-5
Job Sheet 185702



Part No: D4776-5

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-3		
100	Doosan	60 pcs	11/16/18	11/16/18	0.05	3.35	Doosan		
120	QC	60 pcs	11/16/18	11/16/18	0.00	0.00	QC8		
130	HandFinish	60 pcs	11/16/18	11/16/18	0.00	0.29	HandFinish1		
140	QC	60 pcs	11/16/18	11/16/18	0.00	0.00	QC7-4		
150	Packaging	60 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2		
160	QC21-SA	60 Ea	11/16/18	11/16/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - 1-Turn as per Folio and Dwg

DAS
21
9-89

NOV 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.2000 ft (.02 ea)	90-Start up Operation	S127982

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	1	26	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 0.615	Diameter	.625
4	Spacer	0.438Inches ± 0.010	0.448 0.428	Diameter	.437
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	.206

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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 Heckesbury, ON K64 1K7
 CANADA
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Container No: S131231
Part: D4776-5
Job No: 185702
Serial No/Batch: S131231
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 11/24/18

FAULT CATEGORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence